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(21) International Application Number: PCT/DK98/00107 (22) International Filing Date: 20 March 1998 (20.03.98) (30) Priority Data: 0318/97 20 March 1997 (20.03.97) DK (71) Applicant (for all designated States except US): NOVO NORDISK A/S [DK/DK]; Novo Allé, DK-2880 Bagsvaerd (DK). (72) Inventors; and (75) Inventors/Applicants (for US only): JENSEN, Steen [DK/DK]; Sophus Falcks Allé 34, DK-2791 Dragør (DK). HANSEN, Philip [DK/DK]; Skovmindevej 23B, DK-2840 Holte (DK). (74) Common Representative: NOVO NORDISK A/S; Corporate Patents, Novo Allé, DK-2880 Bagsvaerd (DK).		(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, GM, GW, HU, ID, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, US, UZ, VN, YU, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG). Published <i>With international search report.</i>
(54) Title: METHOD FOR PREPARATION OF A THERAPEUTIC POWDER THROUGH COPRECIPITATION OF INSULIN AND ABSORPTION ENHANCER (57) Abstract A process for the preparation of a therapeutic powder formulation comprising particles composed of insulin or an analogue or derivative thereof and an enhancer which enhances the absorption of insulin in the lower respiratory tract is provided. The obtainable powder formulation of insulin and enhancer has a better stability profile than powders of essentially the same composition prepared by spray drying, freeze-drying, vacuum drying and open drying.		

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METHOD FOR PREPARATION OF A THERAPEUTIC POWDER THROUGH
COPRECIPITATION OF INSULIN AND ABSORPTION ENHANCER

Field of the invention

The present invention relates to a process for the preparation of a therapeutic powder formulation comprising particles composed of insulin or an analogue or derivative thereof and an enhancer which enhances the absorption of insulin in the lower respiratory tract.

5 Background of the invention

Diabetes is a general term for disorders in man having excessive urine excretion as in diabetes mellitus and diabetes insipidus. Diabetes mellitus is a metabolic disorder in which the ability to utilize glucose is more or less completely lost. About 2 % of all people suffer from diabetes.

10 Since the introduction of insulin in the 1920's, continuous strides have been made to improve the treatment of diabetes mellitus. To help avoid extreme glycaemia levels, diabetic patients often practice multiple injection therapy, whereby insulin is administered with each meal.

In the treatment of diabetes mellitus, many varieties of insulin preparations have been suggested and used, such as regular insulin, Semilente[®] insulin isophane insulin, insulin
15 zinc suspensions, protamine zinc insulin and Ultralente[®] insulin. Some of the commercial available insulin preparations are characterized by a fast onset of action. Ideally, exogenous insulin is administered at times and in doses that would yield a plasma profile which mimics the plasma profile of endogenous insulin in a normal individual. Insulin preparations
20 containing analogs of human insulin have shown an absorption profile very close to the normal plasma profile, e.g. Lys^{B28}-Pro^{B29} human insulin and Asp^{B28} human insulin. However, these new insulin preparations still has to be injected in connection with a meal. In order to circumvent injections, administration of insulin via the pulmonary route could be an alternative elucidating absorption profiles which mimic the endogenous insulin without
25 the need to inject the insulin.

Description of the background art

Administration of insulin via the pulmonary route can be accomplished by either an aqueous solution or a powder preparation. A description of the details can be found in several references, one of the latest being by Niven, Crit. Rev. Ther. Drug Carrier Sys,

12(2&3):151-231 (1995). One aspect covered in said review is the stability issue of protein formulations, aqueous solutions being less stable than powder formulation. So far, all powder formulations have been described as mainly amorphous.

5 It has been found that when insulin is combined with an appropriate absorption enhancer and is introduced into the lower respiratory tract in the form of a powder of appropriate particle size, it readily enters the systemic circulation by absorption through the layer of epithelial cells in the lower respiratory tract as described in US patent No. 5,506,203. The manufacturing process described in said patent, comprising dissolution of insulin at acid pH followed by a pH adjustment to pH 7.4 and addition of sodium taurocholate before
10 drying the solution by a suitable method, results in a powder composed of human insulin and absorption enhancer in a ratio between 9:1 to about 1:1. The powder is characterized as mainly amorphous determined under a polarized light microscope.

Description of the invention

Definitions

15 The expressions "crystalline" and "amorphous" as used herein corresponds to different states of a powder particle, distinguishable by the following method: An aliquot of particles of the powder are mounted in mineral oil on a clean glass slide. Examination using a polarized light microscope elucidates birefringence for crystalline particles.

20 The expression "enhancer" refers to a substance enhancing the absorption of insulin, insulin analogue or insulin derivative through the layer of epithelial cells lining the alveoli of the lung into the adjacent pulmonary vasculature, i.e. the amount of insulin absorbed into the systemic system is higher than the amount absorbed in the absence of enhancer.

25 By "analogue of human insulin" (or similar expressions) as used herein is meant human insulin in which one or more amino acids have been deleted and/or replaced by other amino acids, including non-codeable amino acids, or human insulin comprising additional amino acids, i.e. more than 51 amino acids.

By "derivative of human insulin" (or similar expressions) as used herein is meant human insulin or an analogue thereof in which at least one organic substituent is bound to one or more of the amino acids.

In the present context the expression "powder" refers to a collection of essentially dry particles, i.e. the moisture content being below about 10 % by weight, preferably below 6 % by weight, and most preferably below 4 % by weight.

5 According to the invention it has surprisingly been found that it is possible to obtain particles composed of both insulin and enhancer despite the fact that enhancers and particularly surface active agents normally inhibits precipitation.

Thus, the present invention relates to a process for the preparation of a therapeutic powder formulation comprising particles composed of insulin or an analogue or derivative thereof and an enhancer which enhances the absorption of insulin in the lower respiratory tract, comprising the steps of:

- a) providing an acidic aqueous solution comprising insulin or an analogue or derivative thereof, an enhancer and optionally zinc;
- b) adjusting the pH value to 4.5 to 7.4, preferably 4.5 to 7, more preferably 4.5 to 6.5, still more preferably 5.5 to 6.2, most preferably 5.5 to 6.1;
- 15 c) precipitating a product comprising insulin or an analogue or derivative thereof, an enhancer and optionally zinc; and
- d) removing the water.

20 The process of the invention results in a powder formulation of insulin and enhancer which elucidates a better stability profile than powders of essentially the same composition prepared by spray drying, freeze-drying, vacuum drying and open drying. By this means it is possible to store the powder formulations of the present invention at room temperature in contrary to human insulin preparations for injections and some amorphous insulin powders without stabilizing agent which have to be stored between 2°C to 8°C.

25 Furthermore, the obtained powder formulations elucidates better flowing properties than corresponding powder formulations disclosed in the prior art.

The enhancer is advantageously a surfactant, preferably selected from the group consisting of salts of fatty acids, bile salts or phospholipids, more preferably a bile salt.

30 Preferred fatty acids salts are salts of C₁₀₋₁₄ fatty acids, such as sodium caprate, sodium laurate and sodium myristate.

Lysophosphatidylcholine is a preferred phospholipid.

Preferred bile salts are salts of ursodeoxycholate, taurocholate, glycocholate and taurodihydrofusidate. Still more preferred are powder formulations according to the invention wherein the enhancer is a salt of taurocholate, preferably sodium taurocholate.

- 5 The preferred analogues of human insulin are fast-acting insulin analogues, in particular analogues wherein position B28 is Asp, Lys, Leu, Val or Ala and position B29 is Lys or Pro; or des(B28-B30), des(B27) or des(B30) human insulin. The most preferred analogues are Asp^{B28} human insulin or Lys^{B28}Pro^{B29} human insulin.

- 10 The preferred derivatives of human insulin are derivatives comprising one or more lipophilic substituents. The preferred lipophilic insulins are acylated insulins such as those described in WO 95/07931, e.g. human insulin derivatives wherein the ϵ -amino group of Lys^{B29} contains an acyl substituent which comprises at least 6 carbon atoms.

- The insulin derivative is most preferably selected from the group consisting of B29-N ϵ -myristoyl-des(B30) human insulin, B29-N ϵ -palmitoyl-des(B30) human insulin, B29-N ϵ -myristoyl human insulin, B29-N ϵ -palmitoyl human insulin, B28-N ϵ -myristoyl Lys^{B28}Pro^{B29} human insulin, B28-N ϵ -palmitoyl Lys^{B28}Pro^{B29} human insulin, B30-N ϵ -myristoyl-Thr^{B29}Lys^{B30} human insulin, B30-N ϵ -palmitoyl-Thr^{B29}Lys^{B30} human insulin, B29-N ϵ -(N-palmitoyl- γ -glutamyl)-des(B30) human insulin, B29-N ϵ -(N-lithocholyl- γ -glutamyl)-des(B30) human insulin, B29-N ϵ -(ω -carboxyheptadecanoyl)-des(B30) human insulin and B29-N ϵ -(ω -carboxyheptadecanoyl) human insulin.
- 15
- 20

In a preferred embodiment the powder formulation of the present invention comprises an insulin derivative as well as human insulin or an analogue thereof.

However, human insulin is the most preferred insulin to be used in the formulation of the present invention.

- 25 In a particular embodiment of the present invention the solution of step a) further comprises zinc, preferably in an amount corresponding to 2 Zn atoms/insulin hexamer to 12 Zn atoms/insulin hexamer, more preferably 2 Zn atoms/insulin hexamer to 10 Zn atoms/insulin hexamer or 4 Zn atoms/insulin hexamer to 12 Zn atoms/insulin hexamer, still more preferably 2 Zn atoms/insulin hexamer to 5 Zn atoms/insulin hexamer.
- 30 Particular good results are obtained when the precipitation in step c) is performed by

mixing insulin and the enhancer before adding the preferred amount of zinc. Moreover, particular good results are obtained when the precipitation in step c) is performed essentially without evaporation of the solution.

Furthermore, step c) is preferably carried out keeping the preparation at rest but essentially the same result is obtained under slight agitation.

In the process of the invention, the temperature during precipitation is preferably kept in the range of 0°C to 32°C, preferably 20°C to 32°C.

The employed molar ratio of insulin to enhancer is preferably 9:1 to 1:9, more preferably between 5:1 to 1:5, and still more preferably between 3:1 to 1:3.

10 The acidic solution of step a) preferably has a pH value in the range of 3.0 - 3.9.

In a preferred embodiment the solution of step a) contains a phenolic compound, preferably in an amount corresponding to at least 3 molecules of a phenolic compound/insulin hexamer. The phenolic compound is preferably m-cresol or phenol, or a mixture thereof.

15 The process of the invention is preferably carried out so as to obtain a substantially crystalline product, i.e. a product in which at least 50% by weight, preferably at least 75% by weight, more preferably at least 90% by weight, of the particles are crystalline.

The powder formulations obtained by the process of the present invention may optionally be combined with a carrier or excipient generally accepted as suitable for pulmonary administration. The purpose of adding a carrier or excipient may be as a bulking agent, stabilizing agent or an agent improving the flowing properties.

20 Suitable carrier agents include 1) carbohydrates, e.g. monosaccharides such as fructose, galactose, glucose, sorbose, and the like; 2) disaccharides, such as lactose, trehalose and the like; 3) polysaccharides, such as raffinose, maltodextrins, dextrans, and the like; 4) alditols, such as mannitol, xylitol, and the like; 5) inorganic salts, such as sodium chloride, and the like; 6) organic salt, such as sodium citrate, sodium ascorbate, and the like. A preferred group of carriers includes trehalose, raffinose, mannitol, sorbitol, xylitol, inositol, sucrose, sodium chloride and sodium citrate.

25 This invention is further illustrated by the following examples which, however, are not to be construed as limiting.

EXAMPLE I

- 625.9 mg human insulin was dissolved in water by adding 2N HCl resulting in a pH = 3.6-3.7. 125 μ L 4 % Zinc chloride solution was added to the insulin solution while mixing. Water was added to 25 mL. 1g sodium taurocholate was dissolved in 10 mL water. To 16 mL of the insulin solution was then added 4 mL of the taurocholate solution while mixing. Water ad 100 mL was finally added while mixing. The preparation with the spontaneous amorphous precipitate was divided in 7 beakers with 10 mL in each. The pH was adjusted to 4.5, 5.0, 5.5, 6.0, 6.1, 6.5, 7.0 and 7.4 while mixing. After standing at rest for approximately 16 hours at 20°C - 25°C, crystals were formed in all preparations.
- 10 An aliquot of each preparation elucidates almost complete crystalline state of the particles as determined under a polarized light microscope. The size of the individual crystals was determined to 1 μ m - 5 μ m.

The supernatant was carefully removed from each of the preparations and the remaining wet crystalline fraction was dried by placing in a vacuumdryer for approximately 5 hours.

- 15 The dry insulin powders were analyzed by RP-HPLC for the content of human insulin and sodium taurocholate and the results showed a proportion of human insulin and sodium taurocholate of 3:1 to 7:1 depending on the actual pH value .

EXAMPLE II

- 625.9 mg human insulin was dissolved in water by adding 2N HCl resulting in a pH= 3.6-3.7. Water was added to 25 mL. 1g sodium taurocholate was dissolved in 10 mL water. The insulin solution was divided in 6 beakers with 4 mL in each. A 0.4 % Zinc chloride solution was added to the insulin solutions while mixing in an increasing amount: 81 μ L, 123 μ L, 164 μ L, 205 μ L, 285 μ L and 410 μ L. To each of the solutions were then added 1 mL of the taurocholate solution while mixing. Water ad 25 mL was finally added while mixing.
- 25 The pH was adjusted to 6.1 while mixing. Spontaneously, an amorphous precipitate was formed in each of the preparations. After standing at rest for approximately 16 hours at 20°C - 25°C, crystals were formed in all preparations.

- An aliquot of each preparation elucidates almost complete crystalline state of the particles as determined under a polarized light microscope. The size of the individual crystals was determined to 1 μ - 5 μ .
- 30

The supernatant was carefully removed from each of the preparations and the remaining wet crystalline fraction was dried by placing in a vacuumdryer for approximately 5 hours.

The dry insulin powders were analyzed by RP-HPLC for the content of human insulin and sodium taurocholate and the results showed a proportion of human insulin and sodium taurocholate of 4:1 to 5:1 depending on the content of zinc.

EXAMPLE III

625,3 mg human insulin was dissolved in water by adding 2N HCl resulting in a pH= 3.6-3.7. 125 μ L 4 % Zinc chloride solution was added to the insulin solution while mixing. Water was added to 25 mL. 1 g sodium taurocholate was dissolved in 10 mL water. The insulin solution was divided in 4 beakers with 1.6 mL in each. To each of the beakers were added 400 μ L of taurocholate solution while mixing. A sodium chloride solution (100 mg/mL) was added while mixing in an increasing amount: 0 μ L, 58 μ L, 116 μ L and 232 μ L. Water ad 10 mL was finally added while mixing. The pH was adjusted to 6.1 while mixing. An aliquot of each preparation elucidates 50% to 80% crystalline state of the particles as determined under a polarized light microscope. The size of the individual crystals was determined to 1 μ - 5 μ .

The dry insulin powders were analyzed for the content of human insulin and sodium taurocholate and the results showed a proportion of human insulin and sodium taurocholate of 3:1 in all the preparations

EXAMPLE IV

2.5 g human insulin was dissolved in water by adding 2N HCl resulting in a pH= 3.6 - 3.7. 500 μ L 4 % Zinc chloride solution was added to the insulin solution while mixing. Water was added to 100 mL. 2.5 g sodium taurocholate was dissolved in 25 mL water. The insulin solution was divided in 9 beakers with 8 mL in each. To 3 insulin solutions (group 1) were added 2 mL, to the next 3 insulin solutions (group 2) were added 2.25 mL and to the last 3 insulin solutions (group 3) were added 2.50 mL of the taurocholate solution while mixing. In each of the 3 groups, a sodium chloride solution (100 mg/mL) was added in increasing amounts: 0 μ L, 290 μ L and 1160 μ L. Water ad 50 mL was finally added while

mixing. The pH was adjusted to 6.1 while mixing. Spontaneously, an amorphous precipitate was formed in each of the preparations. After standing at rest for approximately 16 hours at 20°C - 25°C, crystals were formed in all preparations.

- 5 An aliquot of each preparation elucidates almost complete crystalline state of the particles with no sodium chloride added while the preparations with sodium chloride elucidate approximately 50 % to 80 % crystalline state as determined under a polarized light microscope. The size of the individual crystals was determined to 1 μ - 5 μ .

The supernatant was carefully removed from each of the preparations and the remaining wet crystalline fraction was dried by placing in a vacuum dryer for approximately 5 hours.

- 10 The dry insulin powders were analyzed for the content of human insulin and sodium taurocholate and the results showed a proportion of human insulin and sodium taurocholate of 6:1 to 3:1 in the preparations.

Claims

1. A process for the preparation of a therapeutic powder formulation comprising particles composed of insulin or an analogue or derivative thereof and an enhancer which enhances the absorption of insulin in the lower respiratory tract, comprising the steps of:
 - 5 a) providing an acidic aqueous solution comprising insulin or an analogue or derivative thereof, an enhancer and optionally zinc;
 - b) adjusting the pH value to 4.5 to 7.4, preferably 4.5 to 7, more preferably 4.5 to 6.5, still more preferably 5.5 to 6.2, most preferably 5.5 to 6.1;
 - 10 c) precipitating a product comprising insulin or an analogue or derivative thereof, an enhancer and optionally zinc; and
 - d) removing the water.
2. A process according to claim 1 wherein the enhancer is a surfactant.
3. A process according to claim 2 wherein the surfactant is a salt of a fatty acid, a bile
15 salt or a phospholipid, preferably a bile salt.
4. A process according to claim 3 wherein the surfactant is a salt of taurocholate, preferably sodium taurocholate.
5. A process according to anyone of the preceding claims wherein the solution of step a) contains zinc in an amount corresponding to 2 Zn atoms/insulin hexamer to 12 Zn
20 atoms/insulin hexamer, preferably 4 Zn atoms/insulin hexamer to 12 Zn atoms/insulin hexamer
6. A process according to claim 5 wherein the solution of step a) contains zinc in an amount corresponding to 2 Zn atoms/insulin hexamer to 10 Zn atoms/insulin hexamer, preferably 2 Zn atoms/insulin hexamer to 5 Zn atoms/insulin hexamer.
- 25 7. A process according to anyone of the preceding claims wherein the solution of step a) has a pH value in the range of 3.0 - 3.9.
8. A process according to anyone of the preceding claims wherein the solution of step a) further comprises a phenolic compound, preferably in an amount corresponding to at least 3 molecules of a phenolic compound/insulin hexamer.

9. A process according to claim 8 wherein the solution of step a) comprises m-cresol or phenol, or a mixture thereof.
10. A process according to anyone of the preceding claims wherein the precipitation in step c) is performed essentially without evaporation of the solution.
- 5 11. A process according to anyone of the preceding claims wherein the precipitation in step c) is performed under slight agitation.
12. A process according to anyone of the preceding claims wherein the removal of water in step d) is carried out using vacuum evaporation.
- 10 13. A process according to anyone of the preceding claims which further comprises micronizing the product of step d).
14. A process according to anyone of the preceding claims, wherein the temperature during precipitation is kept in the range of 0°C to 32°C, preferably 20°C to 32°C.
- 15 15. A process according to anyone of the preceding claims, wherein the molar ratio of insulin to enhancer is 9:1 to 1:9, preferably between 5:1 to 1:5, and more preferably between 3:1 to 1:3.
16. A therapeutic powder formulation obtainable by a process according to any one of the preceding claims.
17. A method of treating diabetes, comprising administering to a subject in need thereof a therapeutically effective amount of the powder formulation according to claim 16.

INTERNATIONAL SEARCH REPORT

International application No.

PCT/DK 98/00107

A. CLASSIFICATION OF SUBJECT MATTER

IPC6: A61K 38/28

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC6: C07K, A61K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

WPI, EPODOC, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	EP 0692489 A1 (ELI LILLY AND COMPANY), 17 January 1996 (17.01.96), examples --	1-15
Y	WO 9500151 A1 (UAB RESEARCH FOUNDATION), 5 January 1995 (05.01.95), claims --	1-15
A	WO 9500550 A1 (NOVO NORDISK A/S), 5 January 1995 (05.01.95), examples -- -----	1-15

☐ Further documents are listed in the continuation of Box C.☒ See patent family annex.

* Special categories of cited documents:

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Date of the actual completion of the international search

22 June 1998

Date of mailing of the international search report

27.06.98

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 Facsimile No. +46 8 666 02 86

Authorized officer

Carl-Olof Gustafsson
 Telephone No. +46 8 782 25 00

INTERNATIONAL SEARCH REPORT

International application No.

PCT/DK 98/00107

Box I Observations where certain claims were found unsearchable (Continuation of Item 1 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☒ Claims Nos.: 16
because they relate to subject matter not required to be searched by this Authority, namely:
Methods for treatment of the human body by surgery or therapy, see
PCT Rule 39.1(iv).
2. ☐ Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such
an extent that no meaningful international search can be carried out, specifically:
3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box II Observations where unity of invention is lacking (Continuation of Item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all
searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment
of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report
covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is
restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
☐ No protest accompanied the payment of additional search fees.

INTERNATIONAL SEARCH REPORT
Information on patent family members

09/06/98

International application No.

PCT/DK 98/00107

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
EP 0692489 A1	17/01/96	AU 2168195 A	04/01/96
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